

Work Order ID 92989

November-13-12 8:09:23 AM

92989

U/R

Page 1

Item ID: D2572

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Saddle. Fwd In 205

Start Date: 13/11/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 27/11/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MLS

Date: 12-11-13 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2572

Rev E U/R

OK UP 12/11/13

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

0.00

HAAS I

HAAS CNC vertical machine #1

Memo

Program Batch No. 92989

Double check by: 45

PO

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
3-Machine Step No 3 per Folio FA051 and insp

110

0.00

110

CONVENTIONAL MILLING MACHINE

0.00

Mill Conv

Memo

Conventional Milling Machine

Machine keyway as per dwg D2571 & D2572

12 12-11-29

12 12-11-29

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; font-size: small;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 92989

November-13-12 8:09:23 AM

92989

Page 2

Item ID: D2572

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle. Fwd In 205

Start Date: 13/11/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 27/11/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

PO.

12

0

DAS
25
12-11-20

Quality Control

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

OK 12/11/29

12

0

DAS
14
12-11-20

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

12 12/12-11-29

Hand Finishing

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; font-size: small;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 92989

November-13-12 8:09:23 AM

92989

Page 3

Item ID: D2572

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Saddle, Fwd In 205

Stop *NS2*

Start Date: 13/11/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 27/11/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

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0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

160

QC3- Inspect Part Finish

0.00

160

QC

Quality Control

Memo

Identify as per dwg & Stock Location: SP441

0.00

170

Packaging

Packaging

Memo

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

12x 0

12/11/29

12x d 12/11/29

12

12/11/3028

Picklist Print

November-13-12 8:09:27 AM

Page 1

Work Order ID: 92989

92989

Parent Item: D2572

D2572

Parent Item Name: Saddle, Fwd In 205

Start Date: 13/11/2012

Required Date: 27/11/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: 102.10.02Re-format: Change to Dwg Rev. D & incorporated D2572KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-005		Manufactured	No			100	Each	59.0000	1	12			

D6101-005

Saddle Billet

**

Location	Loc Qty	Loc Code
MAT041	2	
76838	2	
MAT044	55	
79874	11	
81973	4	
90528	40	
MAT045	2	
88960	2	

encl 12/11/29

DART AEROSPACE LTD	Work Order:	92989
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.999	7.999	7.999	7.999		
F	0.490	0.510		.499	.495	.499	.498		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.498	.496	.498	.498		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.566	.563	.566	.563		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.125	.127	.123	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.251	.250	.251		
S	0.115	0.135		.125	.125	.122	.124		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.240	.239	.239	.239		
W	0.115	0.135		.129	.118	.118	.125		
X	0.307	0.312		.311	.312	.312	.312		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.364	.364	.364	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.624	.621	.623	.622		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.232 ^{.240}	.242 ^{.240}	.241		
AE	1.375	1.395		1.387	1.387	1.387	1.387		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.275	.275	.275	.275		
AH	0.240	0.260		.251	.248	.247	.247		
AI	2.000	2.020		2.002	2.001	2.003	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	SK 1 PO
Date:	12-11-26

Audited by:	414
Date:	12/11/29

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	92989
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.999	7.999	7.999	7.998		
F	0.490	0.510		.499	.499	.500	.503		
G	0.257	0.262		.258	.258	.258	.259		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.498	.498	.500	.498		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.561	.563	.567	.566		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.125	.126	.125	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.249	.250	.249	.249		
S	0.115	0.135		.125	.125	.125	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.238	.239	.239	.239		
W	0.115	0.135		.124	.123	.123	.123		
X	0.307	0.312		.312	.312	.312	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.361	.364	.364	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.621	.624	.624	.625		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.240	.240	.241	.248		
AE	1.375	1.395		1.385	1.386	1.386	1.386		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.275	.275	.275	.275		
AH	0.240	0.260		.249	.249	.248	.249		
AI	2.000	2.020		2.004	2.002	2.002	2.004		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	PD
Date:	12/11/28

Audited by:	14
Date:	12/11/29

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order: 92989
Description: Saddle, Fwd Inboard		Part Number: D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				19	110	111	112		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.999	7.999	7.998	7.998		
F	0.490	0.510		.501	.500	.499	.498		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.498	.498	.498	.498		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.576	.576	.576	.576		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.125	.124	.124	.124		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.249	.249	.248		
S	0.115	0.135		.126	.125	.125	.124		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.238	.237	.238	.237		
W	0.115	0.135		.124	.124	.124	.124		
X	0.307	0.312		.310	.311	.311	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.364	.364	.364	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.624	.624	.624		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.249	.249	.248	.248		
AE	1.375	1.395		1.387	1.387	1.385	1.386		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.275	.275	.275	.275		
AH	0.240	0.260		.249	.249	.249	.248		
AI	2.000	2.020		2.004	2.002	2.000	2.001		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									





Measured by: SL	Audited by: [Signature]
Date: 12-11-29	Date: 12/11/29

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	[Signature]

05.12.06

12.04.20

MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC. 06102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- | | |
|---|--|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES) |
|  | CHAMFER 0.063 x 45° ALL AROUND |
|  | CHAMFER 0.033 x 45° (SEE DETAIL C) |

VIEW B-B

Technical drawing of a mechanical part, likely a manifold or flange, showing a top view and a cross-section.

Top View Dimensions:

- Overall width: 4.000
- Distance from left edge to first hole center: 1.495 ± 0.005
- Distance between hole centers: 3.874 ± 0.005
- Distance from right edge to last hole center: 0.500
- Hole diameter (top): $\phi 0.375 \pm 0.005$ (TYP 2 PLACES)
- Hole diameter (bottom): $\phi 0.750$ (TYP)
- Radius of top outer corner: R0.57 (TYP)
- Radius of top inner corner: R0.75 (TYP)
- Radius of bottom outer corner: R0.50 (TYP)
- Radius of bottom inner corner: R0.37 (TYP)
- Distance from left edge to first hole center (bottom): 1.495 ± 0.005
- Distance between hole centers (bottom): 2.500 ± 0.005
- Distance from right edge to last hole center (bottom): 0.500
- Distance from top edge to first hole center: 1.179 ± 0.005
- Distance from top edge to last hole center: 1.179 ± 0.005
- Distance from bottom edge to first hole center: 1.179 ± 0.005
- Distance from bottom edge to last hole center: 1.179 ± 0.005
- Distance from top edge to first hole center (bottom): 1.179 ± 0.005
- Distance from top edge to last hole center (bottom): 1.179 ± 0.005
- Distance from bottom edge to first hole center (top): 1.179 ± 0.005
- Distance from bottom edge to last hole center (top): 1.179 ± 0.005
- Distance from top edge to first hole center (top): 1.179 ± 0.005
- Distance from top edge to last hole center (top): 1.179 ± 0.005
- Distance from bottom edge to first hole center (bottom): 1.179 ± 0.005
- Distance from bottom edge to last hole center (bottom): 1.179 ± 0.005
- Distance from top edge to first hole center (left): 1.179 ± 0.005
- Distance from top edge to last hole center (left): 1.179 ± 0.005
- Distance from bottom edge to first hole center (left): 1.179 ± 0.005
- Distance from bottom edge to last hole center (left): 1.179 ± 0.005
- Distance from top edge to first hole center (right): 1.179 ± 0.005
- Distance from top edge to last hole center (right): 1.179 ± 0.005
- Distance from bottom edge to first hole center (right): 1.179 ± 0.005
- Distance from bottom edge to last hole center (right): 1.179 ± 0.005
- Distance from top edge to first hole center (center): 1.179 ± 0.005
- Distance from top edge to last hole center (center): 1.179 ± 0.005
- Distance from bottom edge to first hole center (center): 1.179 ± 0.005
- Distance from bottom edge to last hole center (center): 1.179 ± 0.005
- Distance from top edge to first hole center (right): 1.179 ± 0.005
- Distance from top edge to last hole center (right): 1.179 ± 0.005
- Distance from bottom edge to first hole center (right): 1.179 ± 0.005
- Distance from bottom edge to last hole center (right): 1.179 ± 0.005
- Distance from top edge to first hole center (left): 1.179 ± 0.005
- Distance from top edge to last hole center (left): 1.179 ± 0.005
- Distance from bottom edge to first hole center (left): 1.179 ± 0.005
- Distance from bottom edge to last hole center (left): 1.179 ± 0.005
- Distance from top edge to first hole center (center): 1.179 ± 0.005
- Distance from top edge to last hole center (center): 1.179 ± 0.005
- Distance from bottom edge to first hole center (center): 1.179 ± 0.005
- Distance from bottom edge to last hole center (center): 1.179 ± 0.005

Grain Direction: Indicated by an arrow pointing upwards.

Notes:

- 0.125 RIDGE
- 0.510 MIN FLAT AROUND ALL HOLES
- 0.25 ± 0.01

SECTION A-A

Technical drawing of Section A-A showing a cross-section of a mechanical part. The drawing includes the following dimensions and features:

- Overall Width:** 2.960 ± 0.020
- Top Surface Radii:** R0.50 (TYP) at both ends.
- Ridge Dimensions:**
 - Distance from end to ridge start: 0.750
 - Ridge height: 0.250
 - Flat top width: 0.240 FLAT ON RIDGE
 - Distance between ridges: 0.125
- Bottom Surface Features:**
 - Radius around pocket: R0.188 (TYP AROUND POCKET)
 - Pocket depth: 0.063
 - Internal radius: R1.385
 - Bottom thicknesses: 0.125 and 0.250
- Reference Dimension:** 1.573 (REF) indicating total height.
- Feature Callout:** "0.250 (TYP ALL RIDGES)" pointing to the top surface.
- Section Marker:** A triangle containing the number "2".

DETAIL C
SCALE 2:1




Technical drawing of a detail of a structural member, showing dimensions and tolerances. The drawing includes a section line B-B and a detail callout C. Dimensions are given in inches with tolerances in parentheses. Key dimensions include: $R2.000^{+0.020}_{-0.000}$, $R0.50$, $R0.063$ (TYP), 0.125 , 0.625 , 0.362 , 0.000 , 0.005 , 125 , $0.760^{+0.005}_{-0.000}$, $2.050^{+0.005}_{-0.000}$, and a 130° angle.

$\phi 0.438^{+0.005}_{-0.000}$
(TYP 4 PLACES)

0.060
4
(TYP)
R0.025
(TYP)

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E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
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